

Date: Thursday, 21/09/2006 9:09:06 AM  
User: Linda Lacelle

# **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 350/212/130 BASKET LID
<b>Job Number</b>	: 28650A		
<b>Estimate Number</b>	: 10193		
<b>P.O. Number</b>	: <i>N/A</i>	<b>Part Number</b>	: D2512
<b>This Issue</b>	: 21/09/2006	<b>Drawing Number</b>	: D2512 REV D2
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: 19/09/2006	<b>Drawing Revision</b>	: D2
<b>Previous Run</b>	: 28511A	<b>Material</b>	: <i>N/A</i>
<b>Written By</b>	: <i>[Signature]</i>	<b>Due Date</b>	: 26/09/2006
<b>Checked &amp; Approved By</b>	: <i>[Signature]</i>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

## **Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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**Comment:** Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)  
Pick:  
3/4"x3/4" 304/316 SS tube .063" wall  
Batch: \_\_\_\_\_

*u*

*see attached*

2.0	D31663	Basket Hoop
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
1 D3166-3 Basket Hoop \_\_\_\_\_

3.0	D2506	Placard
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
1 D2506 Label Plate \_\_\_\_\_

4.0	D23271	Spacer Bushing
-----	--------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick:  
Qty Part Number Description Batch  
2 D2327-1 Bushing \_\_\_\_\_



Date: Thursday, 21/09/2006 9:09:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28650A

Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D22321	Hinge
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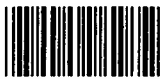


Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	

6.0	D2012117	Clevis
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

7.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	

8.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F Expanded Metal		M102126

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

06/09/250

Date: Thursday, 21/09/2006 9:09:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28650A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-09-25 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y.L  
a.m

06-09-26 (1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

191667 FC 060926

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF. 06/09/26 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A

MF. 06/09/26 (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/09/26 (1)

Job Completion



Date: Tuesday, 9/19/2006 2:13:31 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 350/212/130 BASKET LID
<b>Job Number</b>	: 28650A		
<b>Estimate Number</b>	: 10193		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2512
<b>This Issue</b>	: 9/19/2006	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2512 REV D2
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 28511A	<b>Drawing Revision</b>	: D2
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 9/26/2006
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



**Comment:** Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M102040

11/06/09/22

2.0	D31663	Basket Hoop
-----	--------	-------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D3166-3 Basket Hoop

B28095

11/06/09/22

3.0	D2506	Placard
-----	-------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2506 Label Plate

B26631-2

11/06/09/22

4.0	D23271	Spacer Bushing
-----	--------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2327-1 Bushing

B28334

11/06/09/22

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/09/22		2 D2012-117 clevis instead of 0 <del>removed chg</del> for 130 bskt. B 16369	MA	06/09/22	2	Le	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 22 Date: 06/09/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/19/2006 2:13:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28650A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

*B25238*

*AD 06/09/22*

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

*B27587*

*AD 06/09/22*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

*AD 06/09/22*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 9/19/2006 2:13:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 28650A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: \_\_\_\_\_

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*M/P*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U de-09-26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

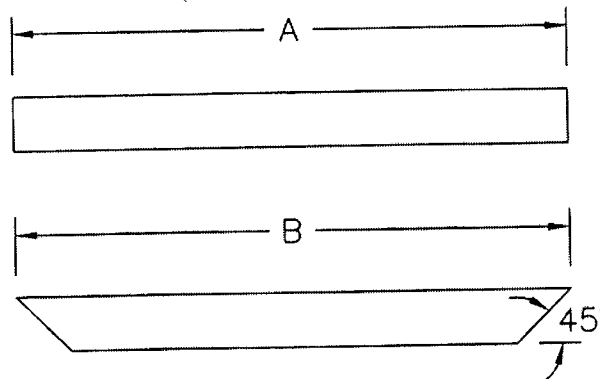


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED  
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITH NOTICE  
WORK ORDER  
NO. 28650 A

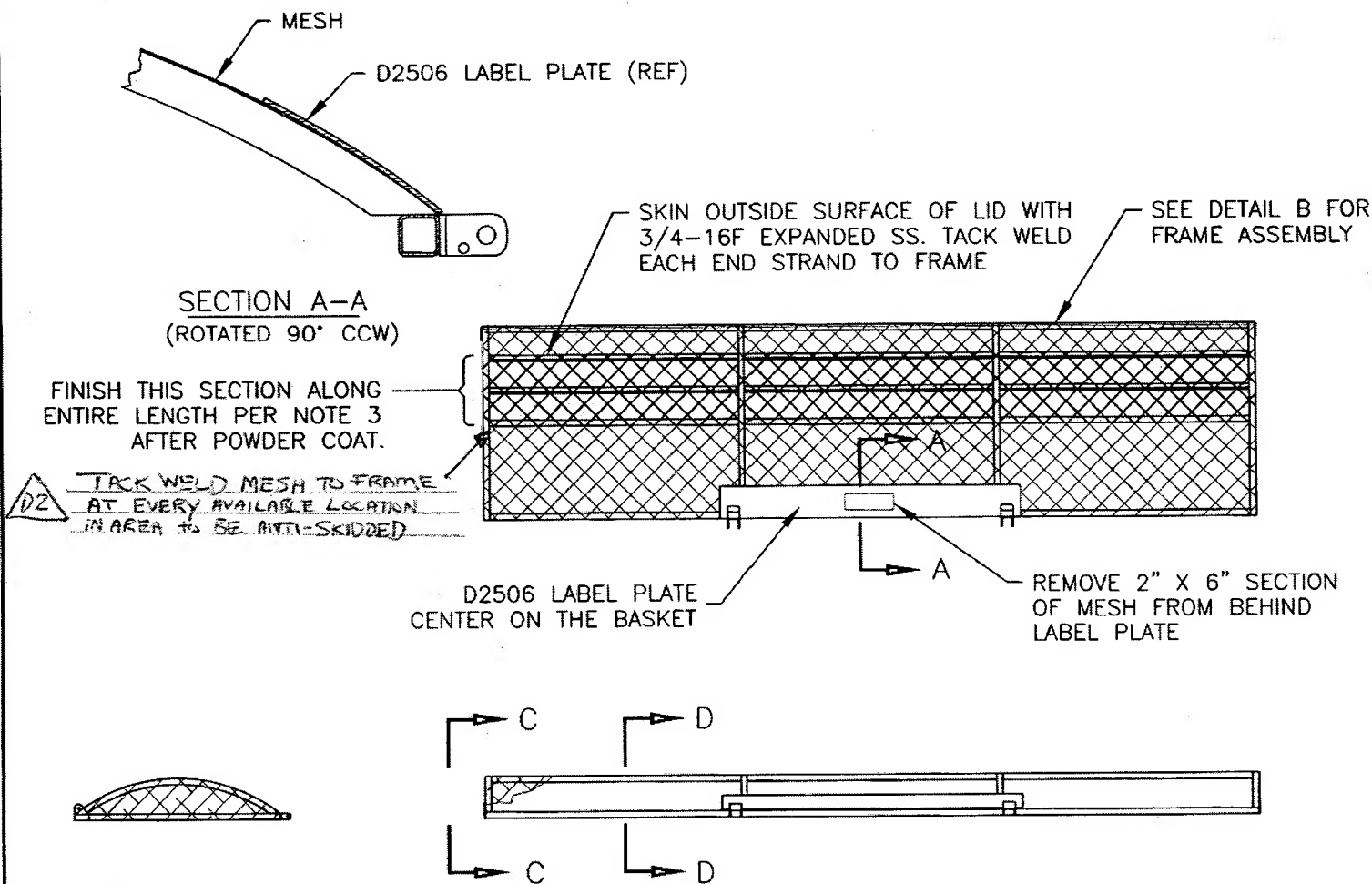
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DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512
		TITLE	BASKET LID ASSEMBLY (350/212)
		SCALE	1:20
		REV. D	SHEET 2 OF 4



#### D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

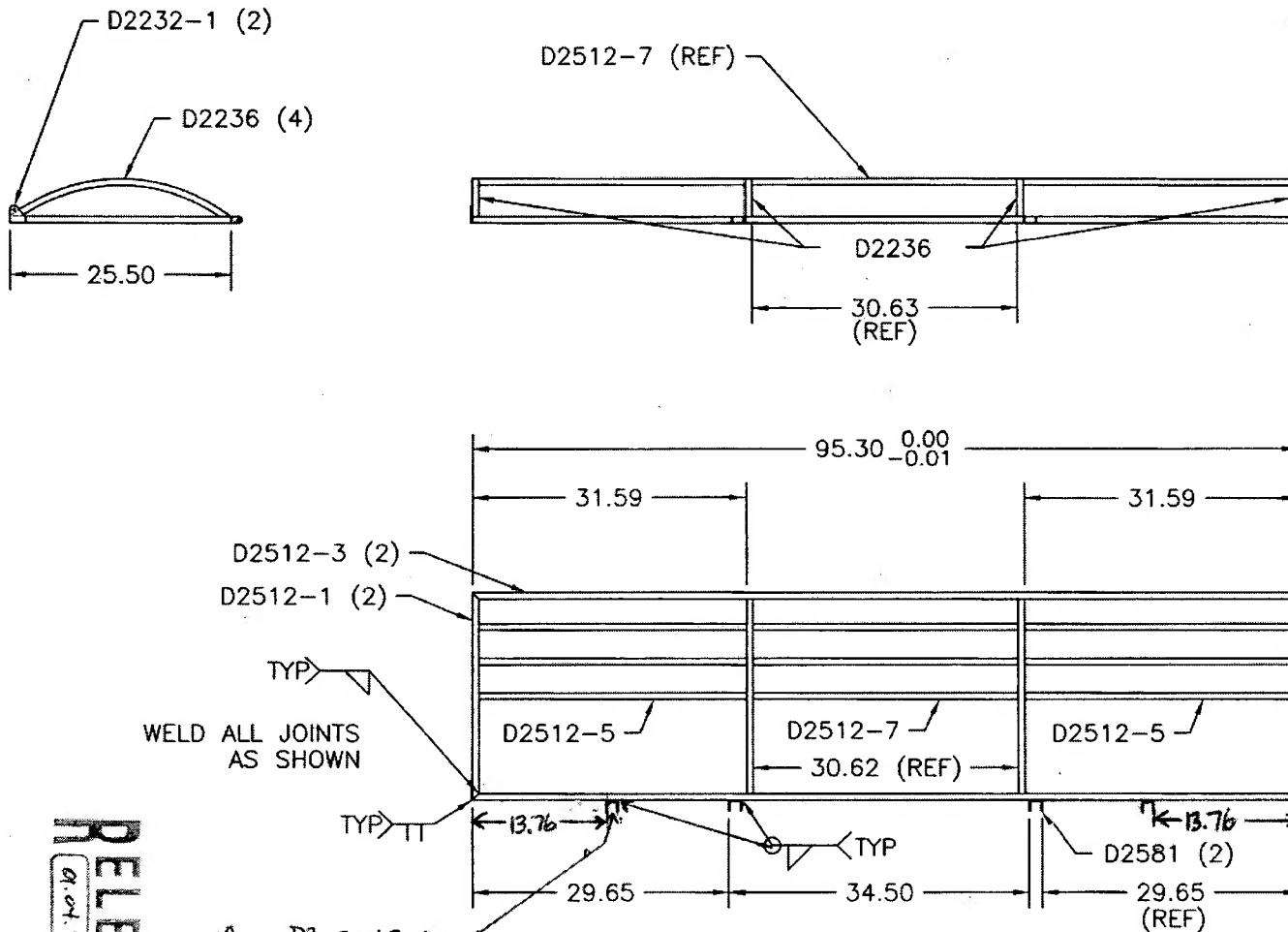
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
NO. 28650A



**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	GP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
01.04.19		D2512
DATE	TITLE	BASKET LID ASSEMBLY (350/212)
		REV. D
		SHEET 3 OF 4
		SCALE 1:20



DETAIL B  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D2012-117 CLEVIS  
ADD FOR D130-701-041  
ONLY (2 PLACES)



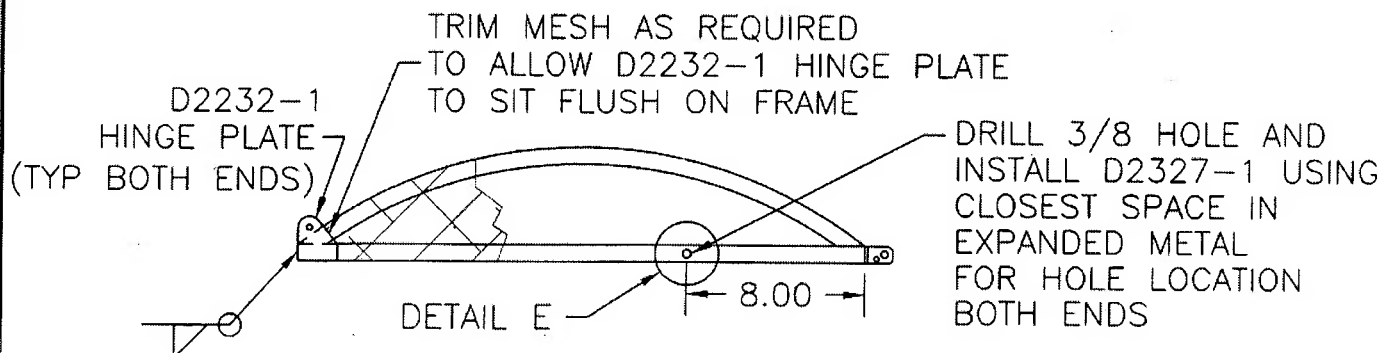
WELD ALL JOINTS  
AS SHOWN

RELEASED  
9.04.2 SUBMIT TO AMENDMENT  
WITHOUT NOTICE

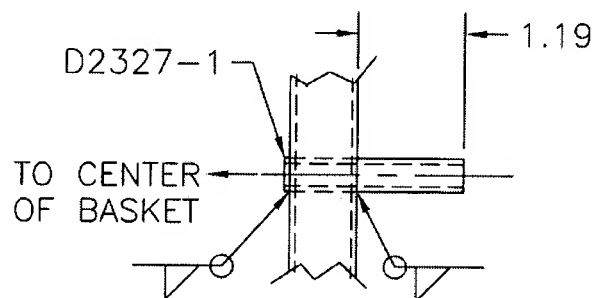
WORK ORDER  
NO. 286504



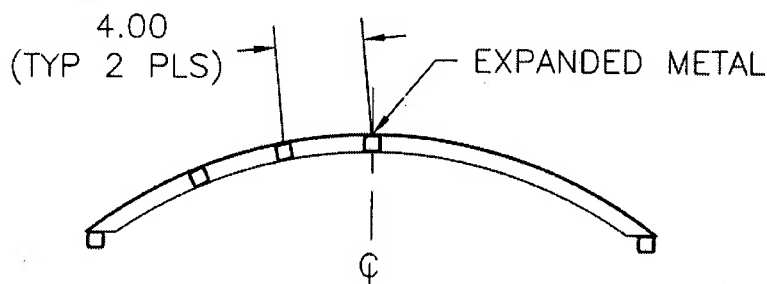
DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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RETURN TO  
ENGINEERING  
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WORK ORDER  
NO 28650A

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01.04.27

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